

Work Order ID 68827

Thursday, April 21, 2011 10:52:37 AM



Page 1

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-748-141

Rev F

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648
2-Turn first side as per Folio FA648
3- File transition lines smooth.

M.M.L 11/07/06

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

M.M.L 11/02/07

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA648
2- File transition lines smooth.
3-Scribe Part & Batch as per Dwg D350-748-141

M.M.L 11/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



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Required Date: 5/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00				1	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1	0		
150 Crosstubes Crosstubes	Large Fab Memo Grind machining marks	0.00 0.00				1			

out 11/07/07

11-07-08

SAD 11-07-12

①

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Item Name: Crosstube Turning Detail

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Outsource1

Outsource process - Heat Treat

0.00

Memo

0.00

Outsource process - Heat Treat

Issue P/O: 14464
Heat Treat to min 180 KSI As per Dwg D350-748-141
(MIL-T-6736 OR AMS 2759-1C)
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

CY 11/07/12 ①

170



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

R 11/8/12 ④

180



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

8 u100102

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Page 4

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Packaging

0.00

Memo

0.00

Identify and stock in kanban rack
Location: 46

11-8-2

200



QC

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

ck 11/08/03

Quality Control

11-08-2
①

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 21, 2011 10:52:34 AM

Page 1

Work Order ID: 68827



Parent Item: D350-748-141TRN



Parent Item Name: Crosstube Turning Detail


Start Date: 4/21/2011

Required Date: 5/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
IPP Rev B Removed polish 08.04.02 EC verified by : DD
IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C
11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125  Crosstube Material		Manufactured	No			110	Each	61.0000	1	1			

Location

HALL

Loc Qty

-61

Loc Code

61

61380

amm.l 11/07/07

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 68827
Description: Crosstube Assembly (AS350/355 High Fwd)	Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: E P 11.01.03	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓	mic	CNC-04
	2.180	+0.005/-0.000	2.185	✓	"	
	2.180	+0.005/-0.000	2.185	✓	"	
	2.237	+0.005/-0.000	2.242	✓	"	
	2.272	+0.005/-0.000	2.277	✓	"	
	2.306	+0.005/-0.000	2.309	✓	"	
	2.339 +.007	+0.005/-0.000	2.340	✓	"	
	2.339 +.007	+0.005/-0.000	2.340	✓	"	
	0.062	+/-0.010	.062	✓	vern	JF-01
	4.26	+/-0.030	4.270	✓	"	
	R0.063	+/-0.010	.063	✓	RG	
	R0.50	+/-0.030	.50	✓	"	
SIDE B	2.240	+0.005/-0.000	2.245	✓	mic	CNC-04
	2.180	+0.005/-0.000	2.185	✓	"	
	2.180	+0.005/-0.000	2.185	✓	"	
	2.237	+0.005/-0.000	2.242	✓	"	
	2.272	+0.005/-0.000	2.277	✓	"	
	2.306	+0.005/-0.000	2.309	✓	"	
	2.339 +.007	+0.005/-0.000	2.345	✓	"	
	2.339 +.007	+0.005/-0.000	2.345	✓	"	
	0.062	+/-0.010	.062	✓	vern	JF-01
	4.26	+/-0.030	4.270	✓	"	
	R0.063	+/-0.010	.063	✓	RG	
	R0.50	+/-0.030	.50	✓	"	
	110.27	+/-0.060	110.260	✓	shape	MM-L-02

Measured by: JMM/Jan	Audited by: J-1	Preliminary Approval:
Date: 11/07/06	Date: 11.07.06	Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

RELEASED
R 2011-01-18 D

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	9	D350-748-141	SHEET 1 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

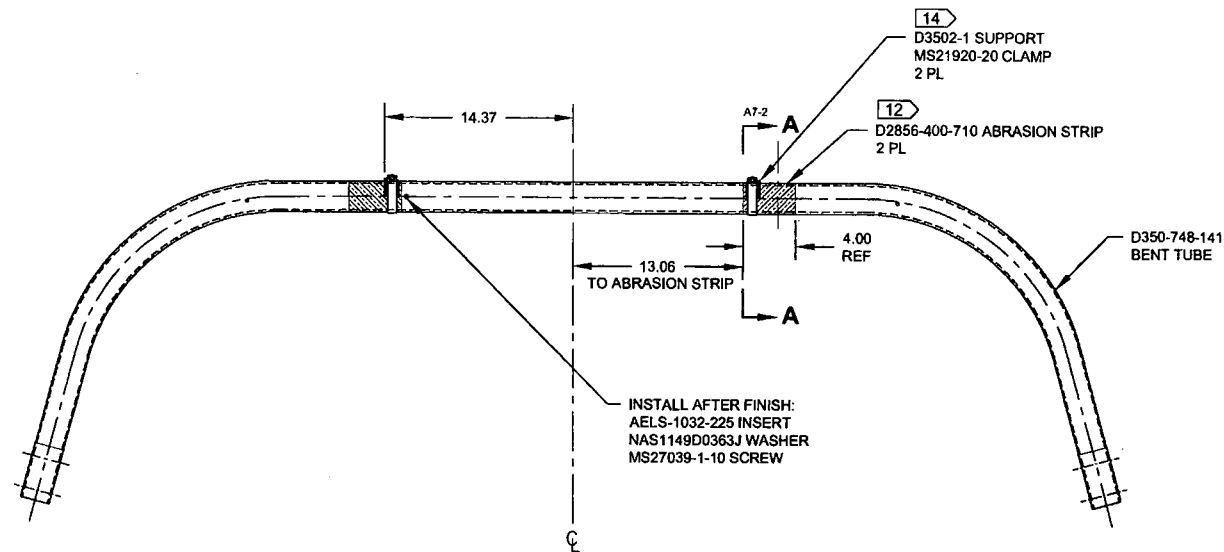
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

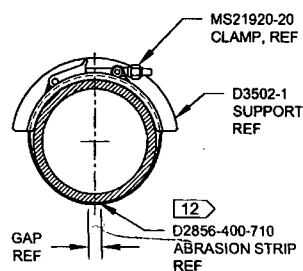
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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**D350-748-141
ASSEMBLY DETAIL**



**SECTION A-A D4-2
SCALE 4X**

RELEASED
R 2011-01-38

65827

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. F
MFG. APPR.	92	D350-748-141	SHEET 2 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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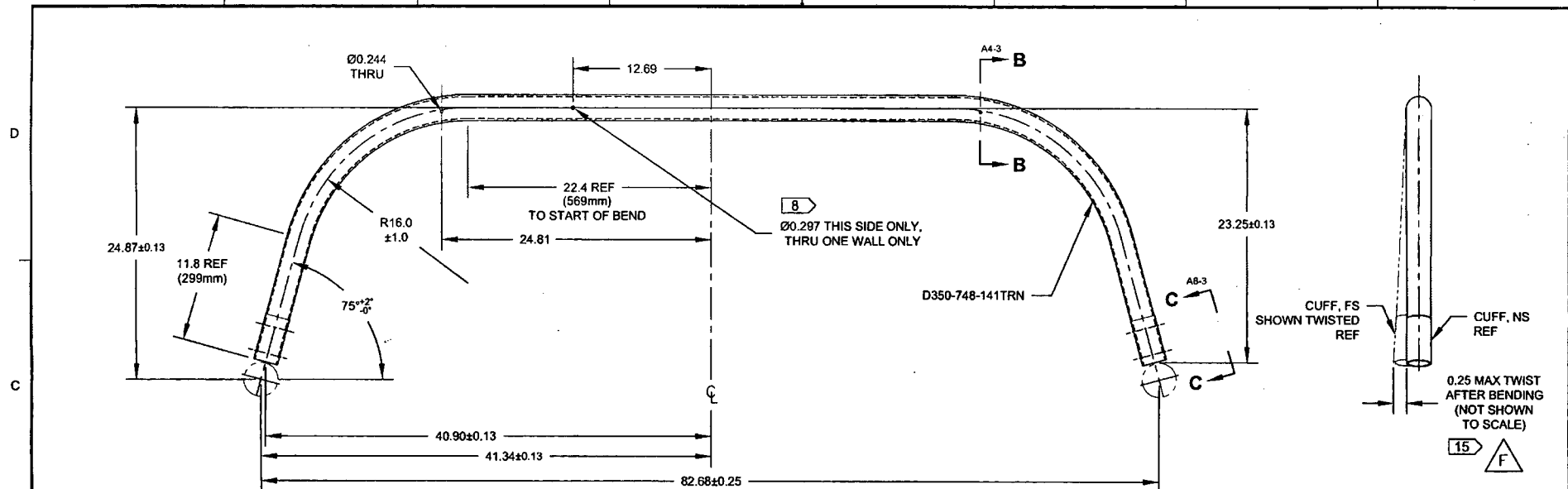
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

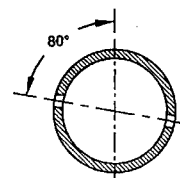
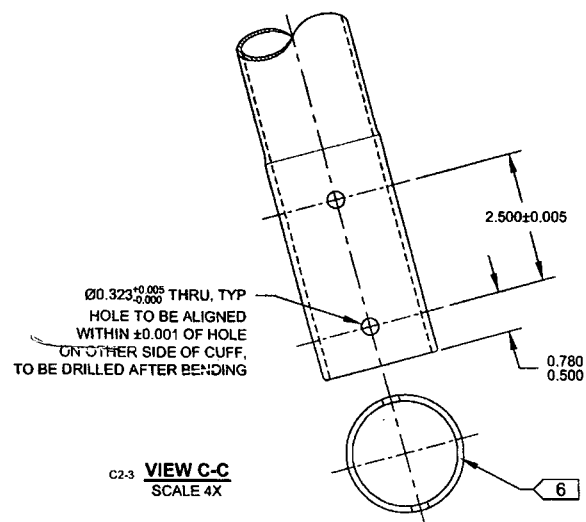
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8 7 6 5 4 3 2 1



D350-748-141
BENDING AND DRILLING DETAIL 10



68827

RELEASED
2011-01-18

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. F
MFG. APPR.	GP	D350-748-141	SHEET 3 OF 4
APPROVED	GP	TITLE	SCALE
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8 7 6 5 4 3 2 1

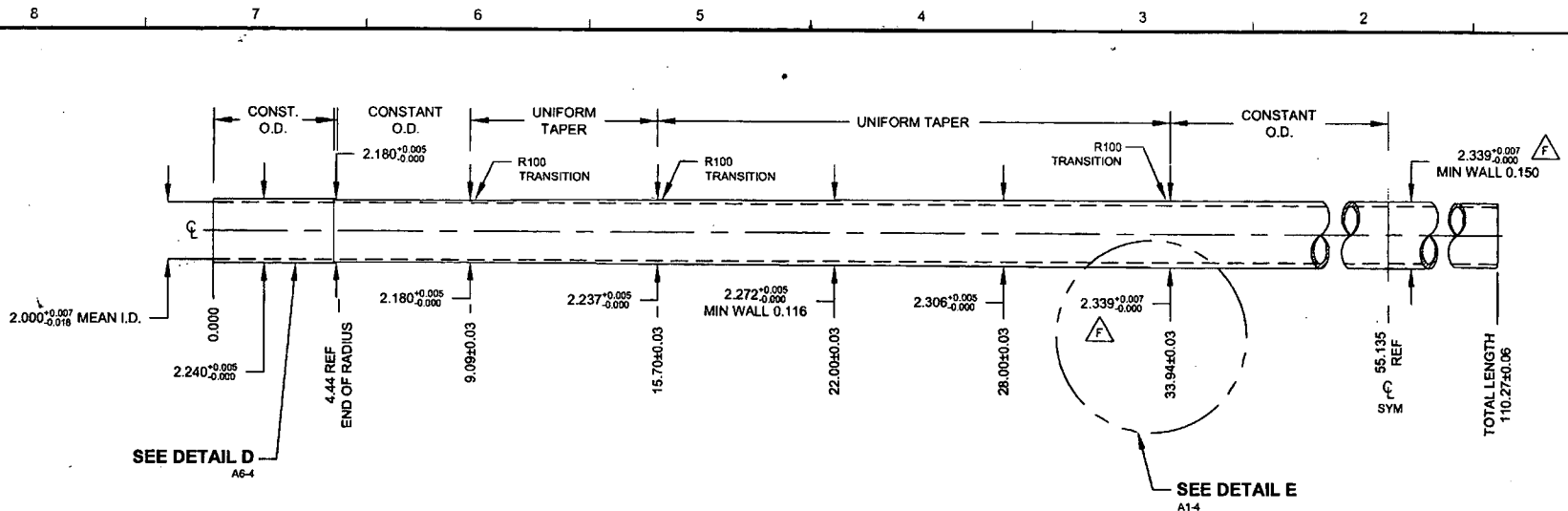
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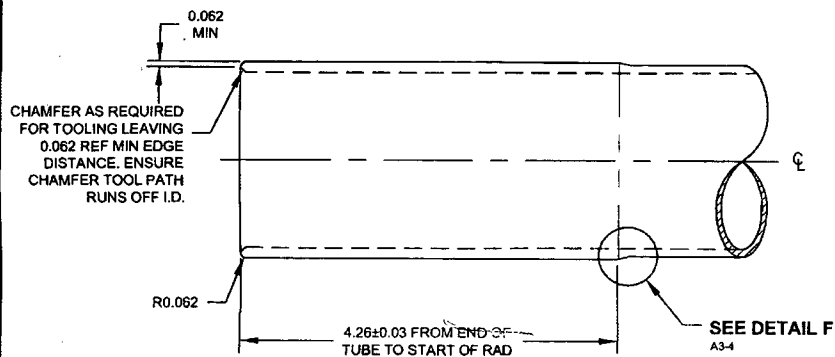
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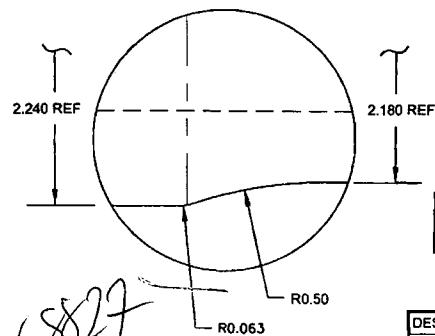
NOTE: Date & initial all entries



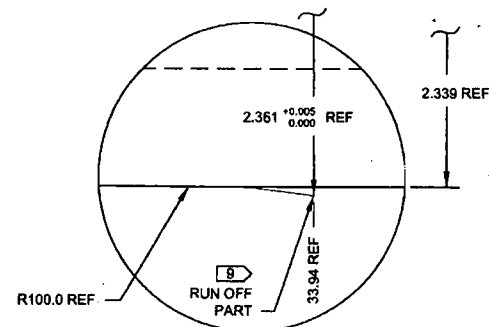
**D350-748-141TRN
TURNING DETAIL**



**DETAIL D:
CROSSTUBE CUFF** C7-4
SCALE 3X



**DETAIL F:
CUFF TRANSITION** A5-4
NOT TO SCALE



**DETAIL E:
TAPER RUN-OFF** C3-4
NOT TO SCALE

RELEASED
2011-01-18

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO. D350-748-141	REV. F
MFG. APPR.	13		SHEET 4 OF 4
APPROVED	13	TITLE	SCALE
DE APPR.	13	CROSSTUBE (AS 350/355 HI FWD)	NTS
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NOTE: Date & initial all entries



VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 132337-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

07/29/2011

MM/DD/YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
07/29/2011		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
14464		NET 30 DAYS

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D350-748	-141 TRN CROSS TUBE	EA	6	6	0
		Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E 100% HARDNESS CHECKED AS PER ASTM E-18, 40/45 HRC MATERIAL: 4130 PARTS WERE GRIT-BLASTED S/N B68818, B68819, B68821 B68827, B70648, B71614 NOTE: NO SERIAL NUMBERS FOUND ON PARTS				
02	MC	MINIMUM CHARGE		1	1	0
03	GB	GRIT BLASTING		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



METAL TREATING INSTITUTE



Heat Treating • Welding

VACUUM BRAZING • HEAT TREATING • SPECIAL PROCESSING • FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL • PLASMA AND OTHER COATINGS

GST No.: R105468102

OAK 132337-1



HEAD OFFICE
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CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

07/29/2011

MM / DD / YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
07/29/2011		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
14464		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141 TRN CROSS TUBE	EA	6	6	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E 100% HARDNESS CHECKED AS PER ASTM E-18, 40/45 HRC MATERIAL: 4130</p> <p>PARTS WERE GRIT BLASTED</p> <p>S/N B68818, B68819, B68821 B68827, B70648, B71614</p> <p>NOTE: NO SERIAL NUMBERS FOUND ON PARTS</p>					

100% HARDNESS TESTED

6pcs - 44/45 HRC

Sulob2



Jul 29/11

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



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